

Work Order ID 52725

October 9, 2009 11:32:04 AM



Page 1

Item ID: D3931-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 10/09/09 Start Qty: 20.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: L

2-Deburr if necessary

= 7 m-h 09/10/14

30X

B 9-10-13



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

27 8/2/10/14

counts
(x30)

7



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

8/5 8/9/10/15

30 0



Brake NC

Memo

0.00

Brake NC

1- bend as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

27 8/2/10/15

counts
(x30)

6



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Item Name: Angle

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Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: B9B

0.00



Packaging

Memo

0.00

Packaging

9/10/16 (300) SP

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 JH
mf 09-10-19

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Picklist Print

October 9, 2009 11:32:04 AM

Page 1

Work Order ID: 52725

Parent Item: D3931-1RevA

Parent Item Name: Angle

Comments:

Start Date: 10/09/09

Required Date: 10/16/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

48.5234

0.4421

1.



304/316 .040 Sheet

189-10-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

48.52343684

110076

2.37053684

112567

46.1529

112567

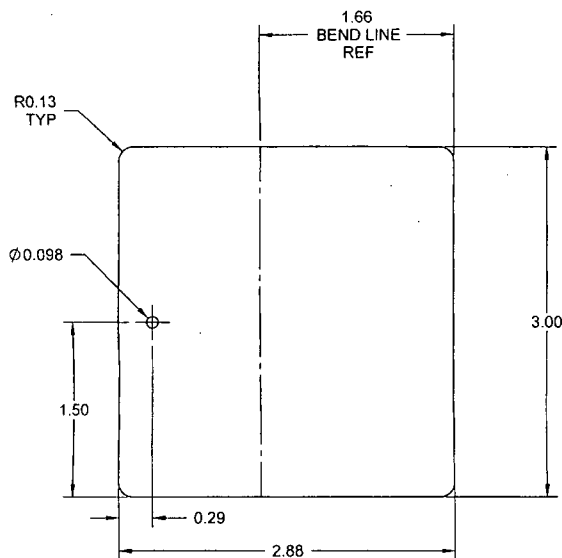
W/O:		WORK ORDER CHANGES					
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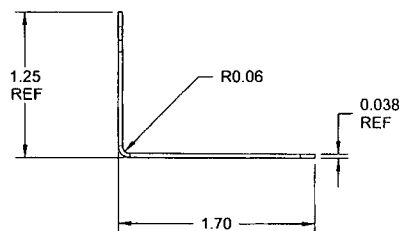
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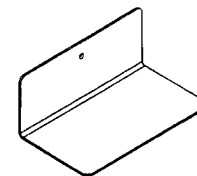


D3931-1F FLAT PATTERN ①



D3931-1 ANGLE
(MAKE FROM D3931-1F)

*W/O
52725*



RELEASED
09/05/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3931-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	09.05.14
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3931	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ANGLE	NTS
DATE	09.05.14	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR ANY PART THEREOF COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

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